

Date: Thursday, 02/04/2009 2:25:09 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : JACK SADDLE
<b>Job Number</b> : 46831	
<b>Estimate Number</b> : 11177	
<b>P.O. Number</b> :	<b>Part Number</b> : D2281
<b>This Issue</b> : 02/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2281 REV G
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : G
<b>Previous Run</b> : 45383	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/04/2009 <b>Qty:</b> 100 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.04.02</u>	
<b>Comment</b> : Est Rev:A Removed from 9 Digit 05-12-02 JLM	
Est: rev B 06.07.17 waterjet EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S14GA	304SS sheet .080
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**Comment:** Qty.: 0.1313 sf(s)/Unit Total: 13.1250 sf(s)

304SS .080

batch: 110993IB 9-4-23

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2281

Dwg Rev: GProg Rev: GIB 9-4-23

2-Deburr if necessary

IB 9-4-23110

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEIB 9-4-23

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 02/04/24 counts  
X110

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** DeburrN/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 02/04/2009 2:25:09 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 46831

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 09/04/29 (110)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts  
S 09/04/29 (x110)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 261

SS 09/05/01 (110)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04 JF

Job Completion



MF  
09-05-01

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46831
<b>Description:</b> Jack Saddle		<b>Part Number:</b> D2281
<b>Inspection Dwg:</b> D2281	<b>Rev:</b> G	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.472	X			
4.114	+/-0.010	4.116	X			
2.933	+/-0.010	2.938	X			
1.535	+/-0.010	1.538	X			
0.354	+/-0.010	.354	X			
0.354	+/-0.010	.354	X			
0.604	+/-0.010	.604	X			
2.000	+/-0.010	2.002	X			
3.396	+/-0.010	3.396	X			
3.646	+/-0.010	3.646	X			
4.000	+/-0.010	4.001	X			
1.525	+/-0.010	1.529	X			
2.475	+/-0.010	2.478	X			
Ø0.323	+0.006/-0.001	.327	X			
0.080	+/-0.010	.074	X			

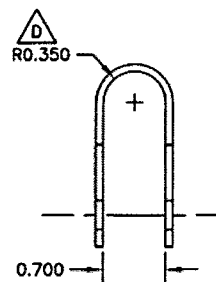
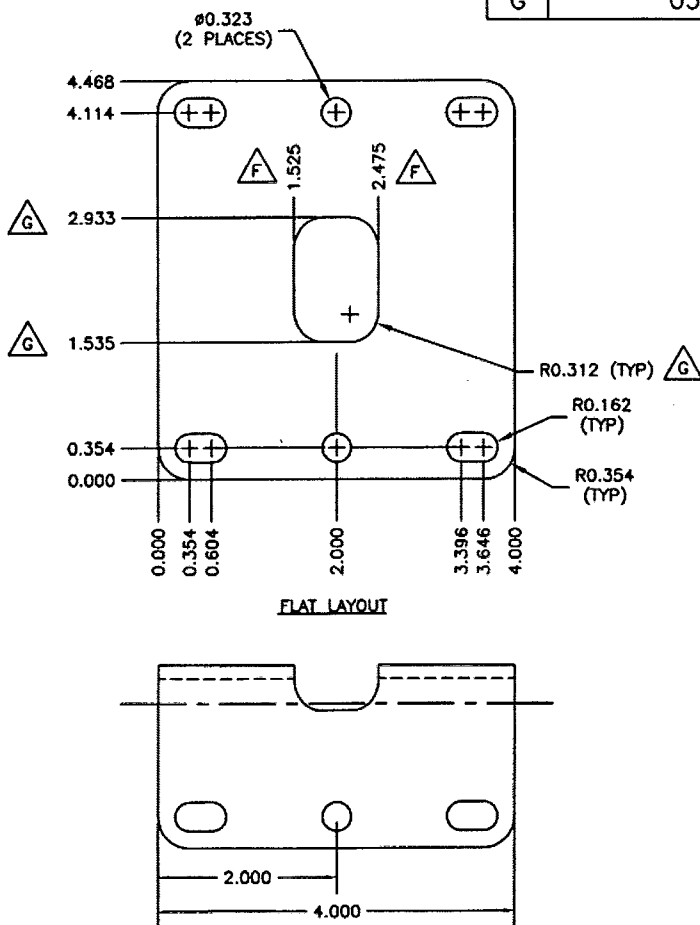
<b>Measured by:</b> IB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-4-23	<b>Date:</b> 07/04/24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE	SCALE 1:2	
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED  
*[Signature]*  
05/08/11



#### D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 46831

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